



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 167783



Part No: D350-591-311

Job Qty: 5 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/6/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Airbus Helicopters - Marignane (CEURO24)

Aéroport International De Marseille Cedex Marignane Marseille, , 13725 France ph:+33 4 42 85 85 85 fx:+33 4 42 85 83 00.

Ship Via:

AIRBUS CHG

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	11/23/17	11/23/17	0.00	0.00	Start Up Large Fab2		17/12/18 SL
110	Large Fab	5 pcs	11/23/17	11/23/17	0.00	4.96	Large Fab 2		17/12/18 SL
120	QC	5 pcs	11/23/17	11/23/17	0.00	0.00	QC9		CPC
130	QC	5 pcs	11/23/17	11/23/17	0.00	0.00	QC5		CPC
140	HandFinish	5 pcs	11/23/17	11/23/17	0.00	0.92	HandFinish1		2017-12-20 JSL
150	QC	5 pcs	11/23/17	11/23/17	0.00	0.00	QC7		CPC
180	Large Fab	5 pcs	11/23/17	11/23/17	0.00	4.96	Large Fab 2		17/12/20 SL
190	QC	5 pcs	11/23/17	11/23/17	0.00	0.00	QC10		PD 17-12-22
200	QC	5 pcs	11/23/17	11/23/17	0.00	0.00	QC5		PD 17-12-22
210	HandFinish	5 pcs	11/23/17	11/23/17	0.00	0.92	HandFinish1		2017-12-22 JSL
220	Powdercoat	5 pcs	11/23/17	11/23/17	0.00	1.45	Powdercoat1		BR 18-01-8
230	HandFinish	5 pcs	11/24/17	11/24/17	0.00	0.92	HandFinish3		BEB 18-01-8
240	QC	5 pcs	11/24/17	11/24/17	0.00	0.00	QC3		PD 11
250	Packaging	5 pcs	11/24/17	11/24/17	0.00	0.00	Packaging1		SL 9-89
260	QC	5 pcs	11/24/17	11/24/17	0.00	0.00	QC4		SMB
265	DC	5 pcs	11/24/17	11/24/17	0.00	0.00	DC		
270	Packaging	5 pcs	11/24/17	11/24/17	0.00	0.00	Packaging3		M.D.
280	QC21-FG	5 Ea	11/24/17	11/24/17	0.00	0.00	QC21		

JAN 11 2

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

Descriptions: D3272 A/R Aluminum Rod _____ 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 1:10 OVEN TEMPERATURE: 320 FINISH TIME: 1:40

265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

wing walk 1138711

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D3067-1	5	38	0	0
	D3219-1	10	57	0	0
	D3272-1	5	3	0	0
180-Large Fab	✓D3065-041 F166514	5	11	0	0

QA Closed:		Date:		Work Order update only																																																																																																																																																																			
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250-Packaging

✓ D3066-1 S012395	10	28	0	0
✓ D3067-1 S012005	5	38	0	0
✓ MS20600-AD4W4 S016823	80	686	0	0
✓ AN3-35A S031759	10	22	0	0
✓ AN4-13A S031758	40	477	0	0
✓ AN5-36A S031756	10	102	0	0
✓ D2230-3 S031754	20	111	0	0
✓ D2618 S031749	10	139	0	0
✓ D2856-400-720 S031741	10	125	0	0
✓ D3235-1 S031730	10	13	0	0
✓ D3278-041 S031725	5	27	0	0
✓ DSI 9410-011	5	0	0	0
✓ MS21042L3 S031714	10	1,433	0	0
✓ MS21042L4 S031709	40	1,670	0	0
✓ MS21042L5 S031705	10	427	0	0
✓ NAS1149D0363J S031703	20	598	0	0
✓ NAS1149D0463J S031701	80	1,482	0	0
✓ NAS1149D0563J S031697	20	1,394	0	0

SP PAS Besoin

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S023973

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PM dart.poulin.mario



Heli - Access - Step LH - High Gear, Long Step, Aerazur
Float Compatible

PART NO: D350 - 591 - 311

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 12/18/17

Job No: 167783

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐			
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Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation 	Disposition 	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Hel-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Hel-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Hel-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Hel-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Hel-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Hel-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
8	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.